

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000314**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 25-Sep-2007**Location:** Changxing Island, Shanghai, China

Submittals(New / Total): **CWR's:** 0 / 4 **HSR's:** 0 / 2 **NCR's:** 1 / 5

Item	Title	Detail
1	Nonconformance Reports (NCRs)	NCR Issued for ABF allowing ZPMC to proceed with weld repairs on 114m Tower Mock-up which exceed 10% of the CJP weld length.
2	Major component movement	<p>77m Tower Mock-up: Performing repairs of Skin Plates A and E Stiffeners.</p> <p>89m Tower Mock-up: No work observed.</p> <p>114m Tower Mock-up: Welding Skin Plate Stiffeners, Performing weld repairs to Skin Plate Stiffeners.</p> <p>Internal Closed-rib Trials (ABF/ZPMC): Macro-etches for ABF Trial are being performed and reviewed by ABF. Observations of completed welds appear to have profile issues (overlap), however unable to confirm which welds represent the most recent tests.</p>
3	Meetings attended	<p>QA met with ABF and ZPMC at 1400 to discuss the schedule for the next two days:</p> <p>77m Tower Mock-up: Finish repair of Skin A and E Stiffeners and perform NDT testing. Flanges for Diaphragms in transit from Wuxi Boiler.</p> <p>89m Tower Mock-up: Machining Diaphragms SA13 and P126.</p> <p>114m Tower Mock-up: Continue welding of Skin Plate stiffeners, Perform repairs to Skin Plate Stiffeners. ABF informed Caltrans that the bent plate from Wuxi should arrive today along with the verification templates. Inspection is scheduled for tomorrow and ABF would like to inspect the material prior to Caltrans QA.</p>

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4	Key conversations	<p>QA David McClary and John Kinsey met with ABF QCM Steve Lawton to discuss calibration standards for the Closed-rib PJP UT procedure, repairs taking place on the Tower Mock-ups that exceed 10% of the weld length, and recent QC oversights related to MT testing which failed to identify cracks.</p> <p>Caltrans met with ABF and ZPMC at 1330 to discuss issues related to fabrication:</p> <p>ZPMC would like to begin Closed-rib Weld Procedure Trials. ABF wants to discuss this internally and will submit a TL-38 if they feel ZPMC is ready.</p> <p>The UT reference blocks for the Closed-rib UT was discussed. ZPMC is having difficulty finding a sub-contractor who can perform EDM machining of the notches. ZPMC proposed to continue making notched blocks with the current method so that a complete set of blocks will eventually be made by trial and error.</p> <p>ABF stated that they have issues with the current list of check samples to be taken. ABF asked about the duplication of check samples if a plate is received that is thicker than a plate of the same heat that was already checked and sampled. Caltrans responded that the specifications require the thickest plate from each heat to be sampled. Any change to this requirement would have to be justified and a RFC and CCO be issued.</p>
5	Quality Assurance Inspectors per shift	3 Day Shift (Brannon, Franco, Viars) 3 Swing Shift (Berger, Dixon, Smith)
6	Logistics	Day and Swing shifts were modified and graveyard shift cancelled due to rescheduling by ZPMC for the Harvest Festival.
Inspected By: McClary, David		Quality Assurance Inspector
Reviewed By: Lowry, Patrick		QA Reviewer